

PROCEDURES MANUAL

PRECIDIUM™ FLOOR COATING SYSTEM



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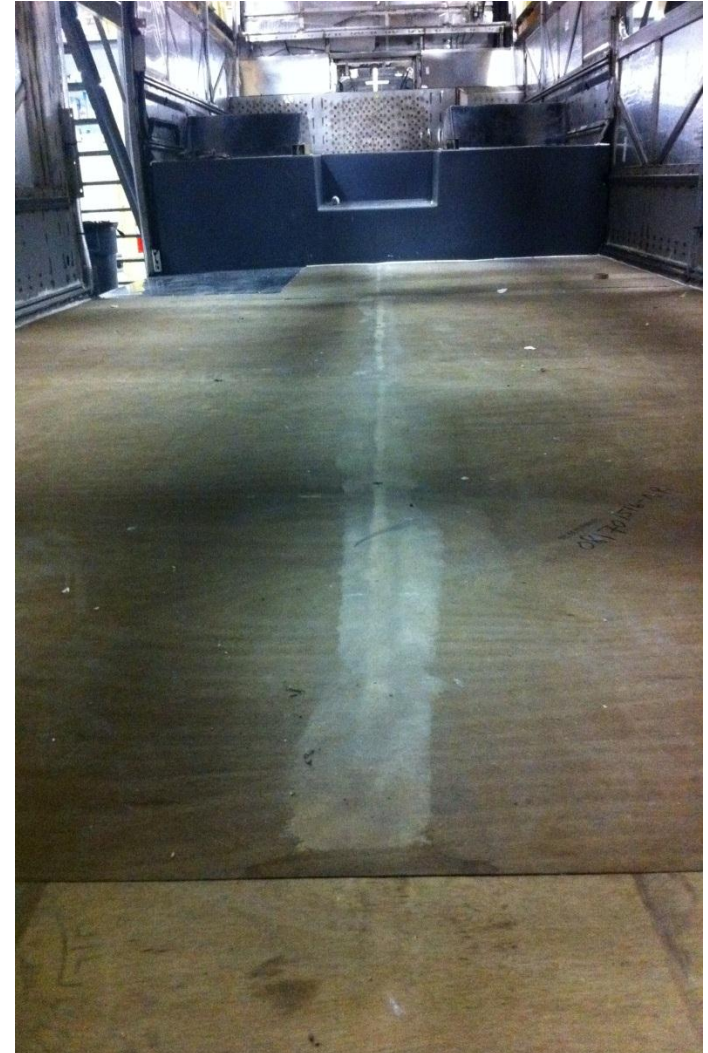
Section 1: Surface Preparation



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1.01 Removal

- 1. All metal trim, covers and edging are to be removed and sand blasted to eliminate all residues, rust, and unwanted material. Immediately following sand blasting, all pieces must be primed with an approved anti-corrosive steel wash primer to maintain a rust-free surface for the floor installation.**
- 2. All wood surfaces are to be sanded down to remove all previous flooring, all adhesive, and all dirt and residue.**
- 3. All steel panels in the sub floor are to be shot blasted and/or hand ground to ensure surfaces are free of all RUST, carpet, adhesive, rubber flooring and any remaining dirt and residue. They must be immediately primed with an anticorrosive steel wash primer to maintain a rust-free surface for the floor installation.**
- 4. All vertical surfaces that will be coated must be cleaned of any paint, silicone caulking, rust, carpet, adhesive and any remaining dirt and residue. All metal substrates must be primed with anti-corrosive steel wash primer.**



Section 1: Surface Preparation

1.02 Transitions

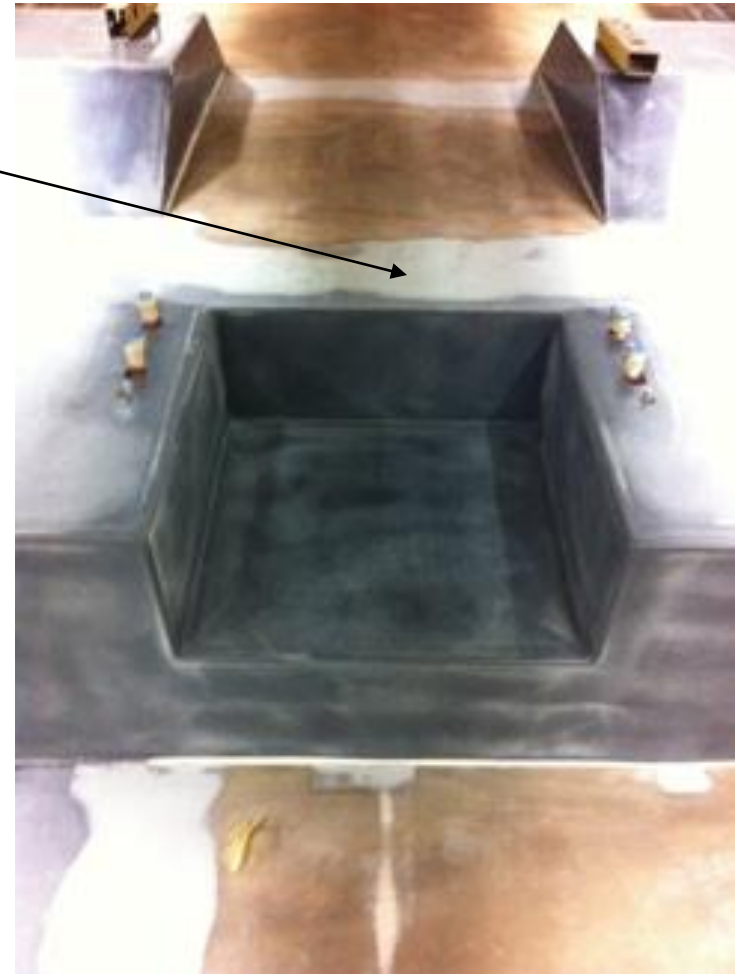
1. All trim and paneling that have a transition to the Precidium™ Transit Floor must not have a height on the top edge higher than 0.1875 inches. Any parts that have a transition from the subfloor to the top of the part greater than this must be lowered to fit within this tolerance.
2. The process to lower the transition is going to be specific for each part and will be decided with the Design/Project Engineer and the Project Managers on the job site.



Section 1: Surface Preparation

1.03 Leveling

1. All cracks, depressions, voids, seams **MUST** be filled with approved, high quality body filler and sanded flush.
2. All screw holes are to be filled with filler prior to reinstallation of the metal trim, covers, and edging. New screws are used on reinstallation.
3. The subfloor should be leveled to remove any low/high areas. This should be smooth to within 1.8 millimeters over 1 meter in any horizontal direction.
4. The entire subfloor should then be rough-sanded with 60-80 grit sand paper.
5. Once the above is complete the entire subfloor is vacuumed to remove all dust, dirt and debris. Once the car is vacuumed, further access to the car will be limited to 2 doors, and all personnel must wear tyvek boot covers when entering the car to prevent the re-entry of dirt and dust.



Section 2: Pre-Spray Preparation



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2.01 Wire Trim

1. The wire trim is to be placed everywhere the Precidium™ Transit Floor terminates; this is defined with the wire side of the wire tape.
2. All areas where wire tape is to be placed must be degreased with Acetone to ensure the tape will stay in place prior to spraying.
3. Immediately following the wire tape being put down, the plastic top layer is removed exposing the adhesive and is taped in place with 3M Masking tape.
4. One end of each continuous piece of wire tape is to have a min. 4 inch piece of wire exposed for removal after spraying.



Section 2: Pre-Spray Preparation

2.02 Plastic/Paper Wrapping

1. The entire inside of the car that is not to be sprayed should be covered with plastic and paper wrap. This is done to ensure that no parts of the car are unnecessarily coated by overspray.
2. All doors, windows and any other opening to the outside of the car should be sealed with paper and plastic to ensure minimum overspray to the outside of the car.
3. The entire outside of the car should be wrapped in 12 foot wide plastic wrap to ensure that the car is protected from overspray.
4. All paper and plastic wrap must be completely sealed to prevent overspray getting under the plastic wrap.

2.03 Masking

1. All wire trim should be masked to the substrate to ensure that it does not move.
2. Any trim pieces that have exposed substrate have to be masked to prevent overspray.
3. The car is to be thoroughly walked through and inspected to ensure there are no exposed areas. If any such areas are found they should be sealed with masking tape.



Section 3.0: Primer Application

3.05 Precidium™ Primer Application

Induction Time & Pot Life:

No Induction time is required.

Pot life is 1 hour at 21°C.

Flash times:

1 to 3 hour flash time is required between coats.

After 3 hour flash **Precidium™ Base Membrane** can be applied.

Note: Product must be recoated within a 3-16 hour window.

Dry Film Thickness:

3.0 to 4.0 mils

